

ABSTRACT

An ejector is coated with a thin, hard, low friction, lubricious coating for use in a mold to eject molded articles from the mold without the use of liquid lubricants.

The preferred ejector has a thin, low friction, coefficient coating with a thickness on

5 the order of 0.00004 inch to 0.0001 inch. This coating provides long lasting, dry lubrication for low friction reciprocation of the ejector within a bore in the mold. The thin lubricous coating allows the ejector to be inventoried and sold in nominal sizes and cut down to the desired size by the mold builder to suit a specific application, and the cut ends are then deburred by the mold builder and finish ground to size, with the 10 lubricous coating remaining intact at the cut end of the ejector. The coating is so thin that the nominal size of the ejector is essentially unchanged. The very thin coating does not chip or flake at the cut end, as would result in cavities into which the plastic could flow and form flashing on the plastic part being molded.

卷之三